



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3537-3

Job Sheet 192267



Part No: D3537-3

Job Qty: 10 pcs

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3537 REV.F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 AUTOMATED PROCESS DD
VERF:JLM IPP REV:C 18.11.09 AS PER DWG REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	10 pcs	4/5/19	4/5/19	0.00	0.60	Waterjet - Flow			JRB 5/23/19
120	QC 8	10 pcs	4/5/19	4/5/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
QC 8 - 47										
QC 8 - 40										
QC 8 - 52										
QC 8 - 23										
130	Small Fab - Brake NC - B4B	10 pcs	4/5/19	4/5/19	0.02	0.46	Small Fab - Brake - 1 - B4B			
							Small Fab - Brake - 2 - B4B			
							Small Fab - Brake - 3 - B4B			
140	QC 5	10 pcs	4/5/19	4/5/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
									Plex 3/20/19 10:22 AM Dart.lajeunesse.marie	

Plex 3/20/19 10:22 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
----------------------------------	---	---	--	--	--

Date :	Sequence #:	QTY Affected :	MRB (QS1042)
--------	-------------	----------------	--------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details:				

					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	Q
					QC 5 - 30	
					QC 5 - 40	
150	Automated Welding - B4B	10 pcs	4/5/19	0.00 0.89	Automated Welding - 1 - B4B	ME MC ✓
160	QC 10	10 pcs	4/5/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	Q
					QC 10 - 58	
					QC 10 - 9	
170	QC 5	10 pcs	4/5/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	Q
					QC 5 - 30	
					QC 5 - 40	
200	Packaging 3-1 - Stock - B4B	10 pcs	4/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	fp-001 Q
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	4/5/19	0.00 0.00		QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	8-89

MAY 24 2019

Part Op 100 - 1-Cut D3537-3 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.4900 sf (.149 ea)	100-Waterjet - Flow - 1	5152146

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	311	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	5.859inches ± 0.010	5.869 5.849		
2	Wearpad	3.500inches ± 0.010	3.510 3.490		
3	Wearpad	1.965inches ± 0.010	1.975 1.955		
4	Wearpad	2.795inches ± 0.010	2.805 2.785		
5	Wearpad	3.625inches ± 0.010	3.635 3.615		
6	Wearpad	0.220inches ± 0.010	0.230 0.210		
7	Wearpad	0.380inches ± 0.010	0.390 0.370		
8	Wearpad	0.063inches ± 0.010	0.073 0.053		

Plex 3/20/19 10:22 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition		Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Loss/Surge ☐ Positioned Wrong gram ☐ Outside Tolerance ection ☐ Drawing ☐ Finish ock Pulled ☐ Part Lost/Missing quence ☐ Misread t-up ☐			

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S183624



Part: D3537-3

Job No: 192267

Serial No/Batch: S183624

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/23/19